

Work Order ID 137826

Thursday, October 08, 2015 9:21:08 AM

137826

Page 1

Item ID: D407-559-113 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: 206L Series/407 Bearpaws - Large
 Start Date: 10/08/15 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 10/09/15 Req'd Qty: 1.00 ***1*** Customer:
 Reference: DISASSEMBLE FOR BEARPAWS

Approvals: Process Plan: (Signature) Date: 15-10-08 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr.	Revision Nbr								
IIN-D206-559	L								

100 Document Control 0.00
100
 DC DOCUMENT CONTROL

Doc.Control -USB or Paperwork Memo 0.00
 PULL FROM STOCK
 D407-559-113 X1
 B: 125202

DISASSEMBLE TOOK BEARPAWS OUT
 D4355-1 X2
 B:128857

ADD NEW BEARPAWS X2
 B:

160 Pick Kit 0.00

160
 Packaging Memo 0.00
 Packaging

✓D4011-1 M130923 x8 St 544
 ✓D4011-5 M131258 x8 St 542
 ✓D4360-041 108 102873 x2 St 608
 ✓D2274 127579 X16 St 006
 ✓D3456-1 129861 x8 St 038

✓AN4C1A M131677 x8 St 344
 ✓M321043-4 M131697 x24 St 304
 ✓NAS1149004631 M132035 St 269 x16
 ✓D4012-1 B131213 x8 St 545
 ✓AN4C21A M128636 x1
 M128973 X15 x16 St 345
 AN4C20A M129390 X16 St 343

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER :							
Misidentified	☐	Past Due	☐								

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Thursday, October 08, 2015 9:21:08 AM

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Item ID: D407-559-113

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: 206L Series/407 Bearpaws - Large

Start Date: 10/08/15 Start Qty: 1.00

1

Cust Item ID:

Required Date: 10/09/15 Req'd Qty: 1.00

1

Customer:

Reference: DISASSEMBLE FOR BEARPAWS

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

QC4- 100% Inspect kits for completeness

0.00

170

QC

Memo

0.00

Quality Control

180

Packaging

0.00

180

Packaging

Memo

0.00

Packaging

REPACKAGE UNDER NEW BATCH NUMBER

PPPD407-559-113

LOCATION: FG015

190

QC21- Final Inspection - Work Order Release

0.00

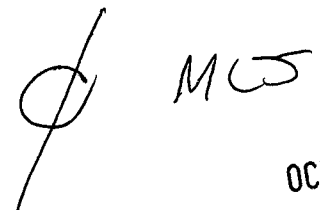
190

QC

Memo

0.00

Quality Control



OCT 15 2015

DQA: _____ Date: _____



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QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

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Work Order ID: 137826

137826

Parent Item: D407-559-113

D407-559-113

Parent Item Name: 206L Series/407 Bearpaws - Large

Start Date: 10/08/15

Required Date: 10/09/15

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP RevA: New issue DD 09.10.29 verified by:EC
 IPP RevB: ECN09-698p DD 09.11.03 verified by:EC
 as per revision K DD 09.11.24 verified by:EC
 per ECN10-575 DD verf:EC
 IPP RevC:
 IPP Rev:D 10.05.27
 IPP REV:E 11-04-11 PER INN REV L JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D407-559-113

Manufactured No

Each 4.0000

D407-559-113

206L Series/407 Bearpaws - Large

125202

**

1
15-10-08

Location

Loc Qty

Loc Code

FG015

4

132192

2

132554

2

D4355-1

Manufactured No

Each 2.0000

D4355-1

Bearpaw

**

-2
15-10-08

Location

Loc Qty

Loc Code

FG

2

128857

2

Each 2.0000

2

D4355-1

Manufactured No

D4355-1

Bearpaw

**

Location

Loc Qty

Loc Code

FG

2

128857

15-10-15

DQA: _____ Date: _____



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